



CEWELD S3

TYPE Solid drawn copper coated wire for the SAW process

APPLICATIONS Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.

PROPERTIES S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.

CLASSIFICATION
 AWS A 5.17: EH10K, A 5.23: EH10K
 EN ISO 14171-A: S3
 F-nr 6
 FM 1

SUITABLE FOR S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | P | S |
|-----|-----|-----|-------|-------|
| 0.1 | 0.1 | 1.5 | 0.015 | 0.015 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | -40°C | -60°C | |
| As Welded | 500 | 620 | 20 | 80 | 60 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175